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1. (PREVIOUSLY PRESENTED) A punch and die tooling apparatus comprising:

a punch and a die for forming a hole in a metal plate;

a die body defining a vertical through bore extending between a top and a bottom surface of the die body;

a horizontally extending ridge formed on a first portion of a wall of the through bore for engaging a portion of a slug cut from the metal plate and tipping the slug away from a face of the punch;

a partially circumferential relief formed on a second portion of the wall substantially opposite from the horizontally extending ridge to facilitate the tipping of the slug away from the face of the punch

wherein the partially circumferential relief is formed vertically closer to the top surface of the die body than the horizontally extending ridge to provide an adequate space to prevent jamming of the tipping slug in the through bore of the die.

2. (CANCELED)

3. (PREVIOUSLY PRESENTED) The punch and die tooling apparatus as set forth in claim 1, wherein the partially circumferential relief defines a relief area extending between the circumferential relief and the bottom surface of the die body.

4. (PREVIOUSLY PRESENTED) The punch and die tooling apparatus as set forth in claim 1, wherein the horizontally extending ridge and the partially circumferential relief are formed by an overlapping upper and lower offset bores.

5. (PREVIOUSLY PRESENTED) The punch and die tooling apparatus as set forth in claim 4, wherein the lower bore is larger than the upper bore.

6-11. (CANCELED)

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